

Date: Wednesday, 2/1/2006 11:44:45 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 25708					
Estimate Number	: 11027					
P.O. Number	: N/A			Part Number	: D28021	
This Issue	: 2/1/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2802 REV A	
First Issue	: N/A		Type	: MACHINED PARTS		
Previous Run	: N/A			Project Number	: N/A	
Written By	: <u>SEE Below.</u>			Drawing Revision	: A	
Checked & Approved By	: <u>JK 06.02.01</u>			Material	: N/A	
Comment	: Est:B 02.03.18 Re-format. NG			Due Date	: 2/28/2006	
				Qty:	8	
				Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
	Comment: Qty.: 1.5750 f(s)/Unit Total : 12.6000 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 bar 6.00" x 0.50" Batch: <u>M 18463</u>	
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks 15.800" long	J.L 06.02.10 8
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA101 Counter sink .375 dia as per dwg	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L 06.02.10 8
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	J.L 06.02.10 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/1/2006 11:44:46 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25708

Part Number: D28021

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr NO sharp edges.

DL 06/02/13

(8)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

N/A

(8)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~WA~~ WA

WA-2 Job 06-02-13 = 8

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5/1-06/02/14

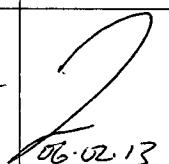
(8)

DP 06/02/14

(8)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.02.13	8	parts to go to welding. No paint required (remove paint) Permanent change.	RL	06.02.13			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	25708
Description: AFM	Part Number:	D28021
Inspection Dwg: D2802 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$	.501	✓			
.030	"	.030	✓			
$\phi .191$	$\pm .005$	.192	✓			
1.500	$\pm .010$	1.500	✓			
.100	"	.101	✓			
9.358	"	9.358	✓			
$\phi .507$	$+.0 -.001$	.507	✓			
.250	$\pm .010$	.250	✓			
2.033	"	2.033	✓			
.300	"	.300	✓			
1.000	"	1.001	✓			
2.000	"	2.000	✓			
1.347	"	1.348	✓			
$\phi .507 \times 250$		.507x24	✓			
.75	$\pm .030$	.750	✓			
.125	$\pm .010$	.125	✓			
.4.0	$\pm .030$	4.0	✓			
.2.0	"	2.0	✓			
5.541	$\pm .010$	5.543	✓			
<del>1.750</del>	"					
.125	$\pm .010$	.122	✓			
.500	"	.499				
.032	"	.032	✓			

Measured by:	J.L	Audited by:	gjl	Prototype Approval:	N/A
Date:	06/02/09	Date:	06/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	